

Work Order ID 146826

Tuesday, May 24, 2016 9:55:41 AM

146826

Page 1

Item ID: D066-1001-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: R66 Bearpaws with Wearplates - Large

Stop ***NS2***

Start Date: 5/11/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1001	REV B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-013								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

DAS
6
9-89

JUN 14 2016

DAS
21
9-89
DAS
6
9-89

16 06-16

AUG 19 2016

CHG 003

JUL 07 2016

DAS
28
9-89

DAS
6
9-89

AUG 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (Q51042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐					

Work Order ID 146826

Tuesday, May 24, 2016 9:55:41 AM

146826

Page 2

Item ID: D066-1001-013**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** R66 Bearpaws with Wearplates - Large**Start Date:** 5/11/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 5/24/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1001-013								
	Location: <u>F6013</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

2 **DAS**
28
9-89 **AUG 19 2016**

DAS
21
9-89 **AUG 19 2016**

DAS
21
9-89 **AUG 19 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, May 24, 2016 9:55:41 AM

Page 1

Work Order ID: 146826

146826

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM IPP REV:C
15.04.08 AS PER CHG003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3456-1		Manufactured	No				Each	101.0000		8			
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D3456-1

Washer

**

PC

Location	Loc Qty	Loc Code
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FG	7	
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25701	7	
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ST038	44	
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141989	44	
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ST038A	50	
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144158	50	
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Each	32.0000	
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DAS
28
9-89

D3556-1

D3556-1

Clamp

Location	Loc Qty	Loc Code
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ST542	32	
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143882	32	
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Each	268.0000	
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**

PC

D3601-1

D3601-1

Radius Block

Location	Loc Qty	Loc Code
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ST045	266	
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144330	26	
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144718	240	
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ST046	2	
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141269	2	
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DAS
28
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JUL 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID: 146826

146826

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

D4930-3 Manufactured No

Each 1.0000

D4930-3
Bearpaw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST462A

1

112356

1

Each

6.0000

**

2 4

145722

PC

DAS
28
9-89

D4952-041 Manufactured No

D4952-041
Wearplate Assembly

DAS
6
9-89

Location

Loc Qty

Loc Code

ST188

6

114155

6

Each

0.0000

**

8

2XB147873

PC

DAS
28
9-89

D4953-1 Manufactured No

D4953-1
Cushion

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

over003

125

m134606

125

ST344

34

m134180

34

Each

169.0000

**

8

B144780

DAS
28
9-89

AN4-12A Purchased No

AN4-12A
Bolt

DAS
6
9-89

**

8

PC M13 606 x 7

DAS
28
9-89

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order ID: 146826

146826

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

Each

438.0000

8

AN4-15A

Bolt

**

M135 127 PC

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

26

120449

26

OVER002

150

m134762

150

over003

200

m134676

200

ST343

62

m134606

62

AN4-16A

Purchased

No

Each

212.0000

8

AN4-16A

Bolt

**

PC

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

207

M134606

7

M134702

100

M134762

100

8

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Work Order ID: 146826

146826

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

Each

3,247.000

16

NAS1149D0463.J
WASHER

**

PC

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

146

M132035

21

M134508

125

ST260a

2600

M134754

2600

ST263

501

M134634

501

Each

2,027.000

24

**

M134861 PC

MS21042L4

Purchased

No

MS21042L4
Locknut

Location

Loc Qty

Loc Code

GA

187

m133769

187

OVER007

1500

m134676

500

m134762

1000

ST303

243

m134606

243

ST305

97

m130922

97

DAS
6
9-89

DAS
28
9-89

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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
<i>Bearpaw Installation (Small)</i>	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
<i>Bearpaw Installation (Large)</i>	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)